

50

Date: Monday, 11/19/2007 4:07:07 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212/205 HIGH FED X-TUBE ASSEMBLY
Job Number	: 35893		
Estimate Number	: 10254		
P.O. Number	: <u>N/A</u>	Part Number	: D212664101
This Issue	: 11/19/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D212-664-141 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 35892	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 12/10/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	Est Rev:E 04-02-16 Reformat KJ/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM Est Rev:G 07-04-30 As per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101CHG003

08/01/03

2.0	D6005128	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

1	D6005-128	Crosstube	<u>329110</u>
---	-----------	-----------	---------------

Check OD = 2.750"; ID = 2.000"

BG 07.11.26 (1)

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA113

2-Turn first side as per Folio FA113

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141.

BG 07.11.26 (1)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

BG 07.11.26 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:07:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 35893

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA113

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141.

BC 07-11-26 (1)

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BC 07-11-26

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/11/27 (1)

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

BC 07-11-26 (1)

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AWM 07-11-27

1-Polish entire outside surface of crosstube

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 7-11-27

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:07:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 35893

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

EL 7-11-30

13.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

07/11/30

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

SR

7-12-3

AWM 07-12-11

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

AWM 07-12-11

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/30

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 5299

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

07/12/17

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

07/12/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:07:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 35893

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D212-664-141

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

22.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1

Support

35579

27 07-12-30

23.0

D3595

Rubber Cushion (per sq ft)



D3595063450 mi 2008/1/4



Comment: Qty.: 0.0840 sf(s)/Unit Total : 0.0840 sf(s)

Rubber Cushion (per sq ft)

.630" X 4.5" 4PCS

Batch:

35124

27 07-12-30

24.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-25

Clamp

106341

27 07-12-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:07:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 35893

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install supports with magnobond as per QSI 015 Adhere for 12 Hrs

A/R 6398 Magnobond

Batch: 105379

Expiry Date: 08-05-01

RT 07-12-30

2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

RT 07-12-31

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17-12-31

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

PLACARD

Batch: 1734954

SP

29.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M106242

SP

30.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M106242

SP

31.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch: M105906

8/02/02 SP (H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:07:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 35893

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch:

M107374

8/01/02

50

33.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/03

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

Rev C

8/1/03



35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/08/01/04

Job Completion



2008/1/4

U

35893 212 664 101

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35893
Description: Crosstube Assembly (205/212/412 High Fwd)		Part Number:	D212-664-141
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

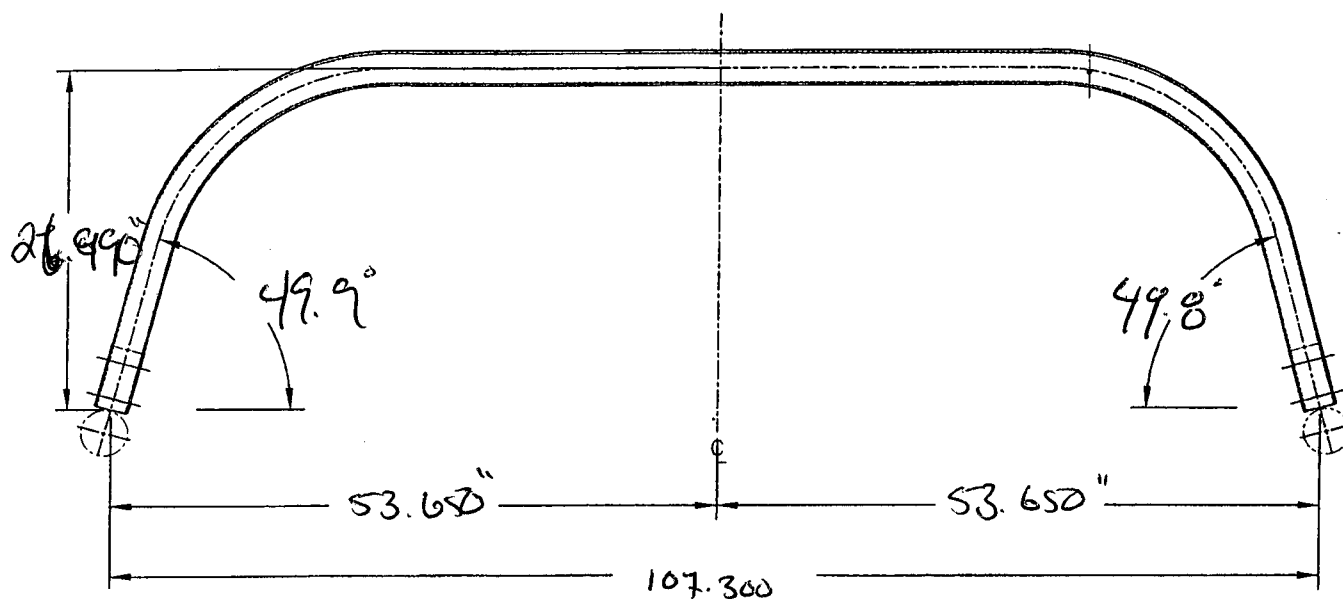
	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	2.740	+0.005/-0.000	2.744	✓			
	5.097	+/-0.030	5.097	✓			
	2.304	+0.005/-0.000	2.308	✓			
	2.340	+0.005/-0.000	2.344	✓			
	2.398	+0.005/-0.000	2.402	✓			
	2.448	+0.005/-0.000	2.452	✓			
	2.498	+0.005/-0.000	2.502	✓			
	2.549	+0.005/-0.000	2.553	✓			
	2.599	+0.005/-0.000	2.599	✓			
	2.671	+0.005/-0.000	2.673	✓			
	2.701	+0.005/-0.000	2.703	✓			
SIDE B	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	2.740	+0.005/-0.000	2.743	✓			
	5.097	+/-0.030	5.097	✓			
	2.304	+0.005/-0.000	2.308	✓			
	2.340	+0.005/-0.000	2.344	✓			
	2.398	+0.005/-0.000	2.402	✓			
	2.448	+0.005/-0.000	2.451	✓			
	2.498	+0.005/-0.000	2.501	✓			
	2.549	+0.005/-0.000	2.553	✓			
	2.599	+0.005/-0.000	2.602	✓			
	2.671	+0.005/-0.000	2.673	✓			
	2.701	+0.005/-0.000	2.703	✓			
	126.51	+/-0.020	126.51	✓			

Measured by:	ISG	Audited by:	J.F.	Prototype Approval:	N/A
Date:	07-11-26	Date:	07/11/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
C	07.05.28	Dwg Rev updated	KJ/JLM	

DART AEROSPACE LTD		Work Order:	35893
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	<i>[Signature]</i>
Date	07/11/30

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED QD	APPROVED [Signature]	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

RELEASED07.04.24 **[Signature]**

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

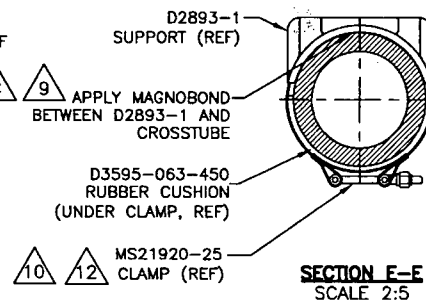
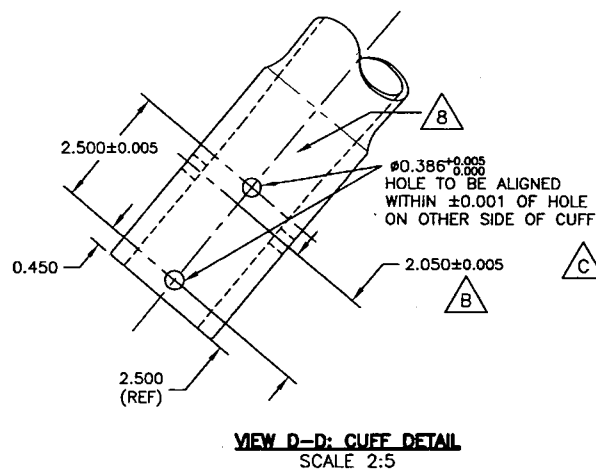
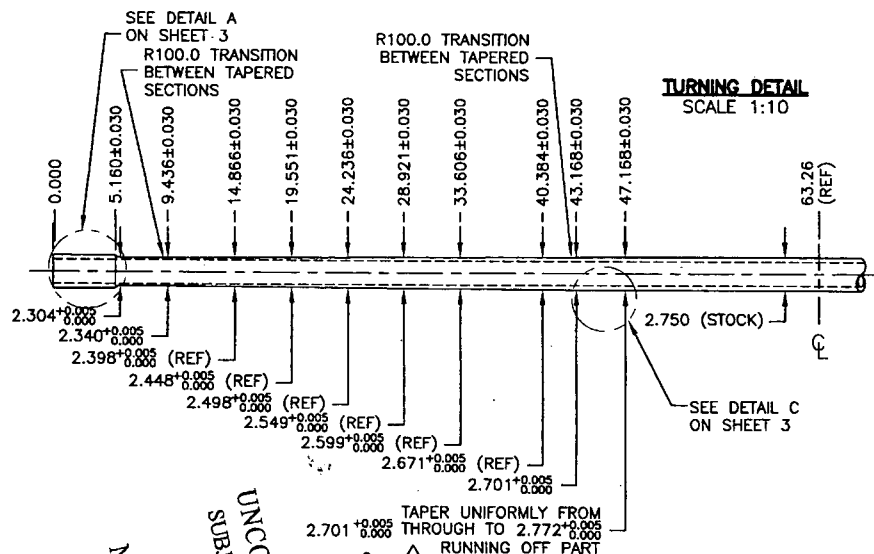
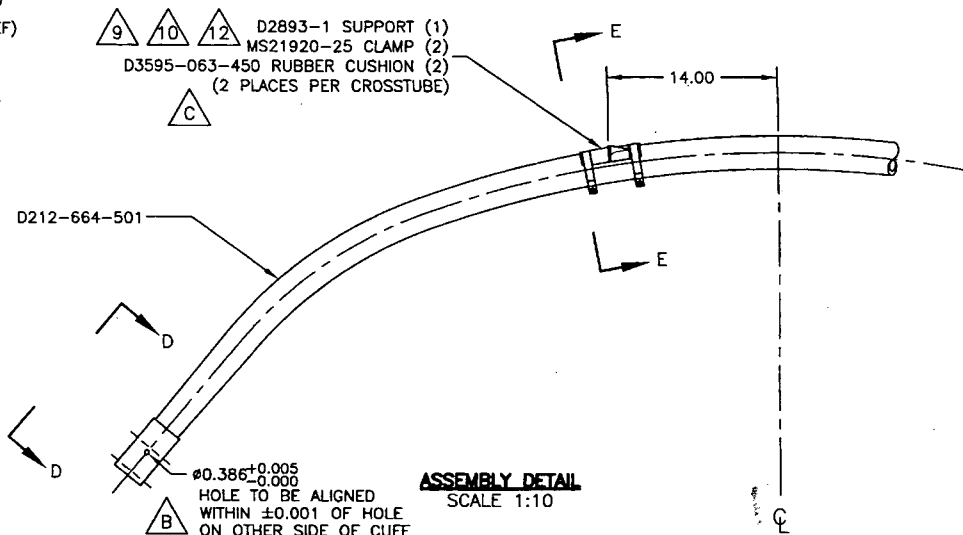
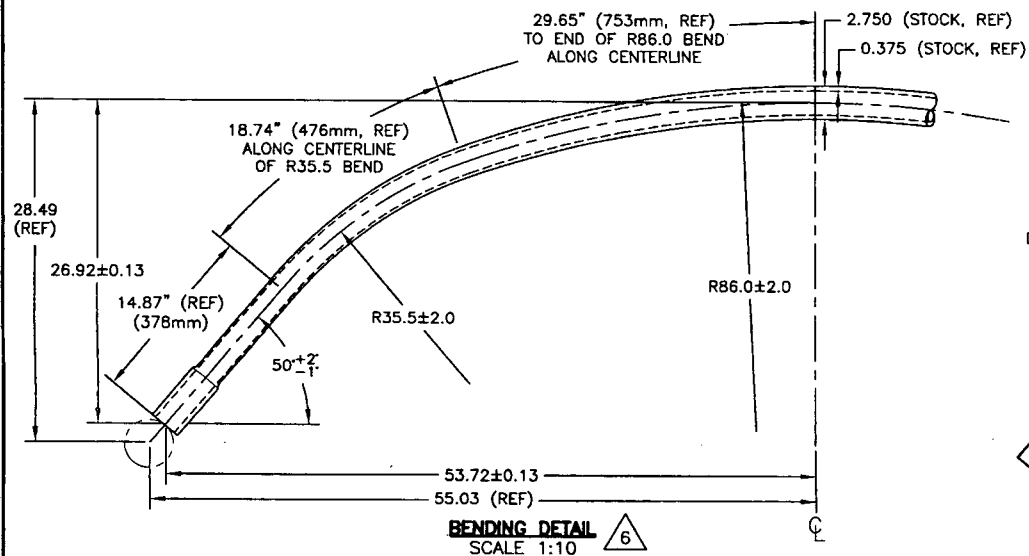
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35893

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



RELEASED

07.04.24

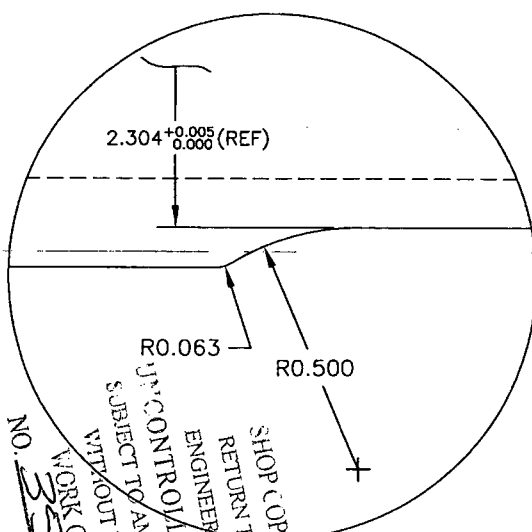
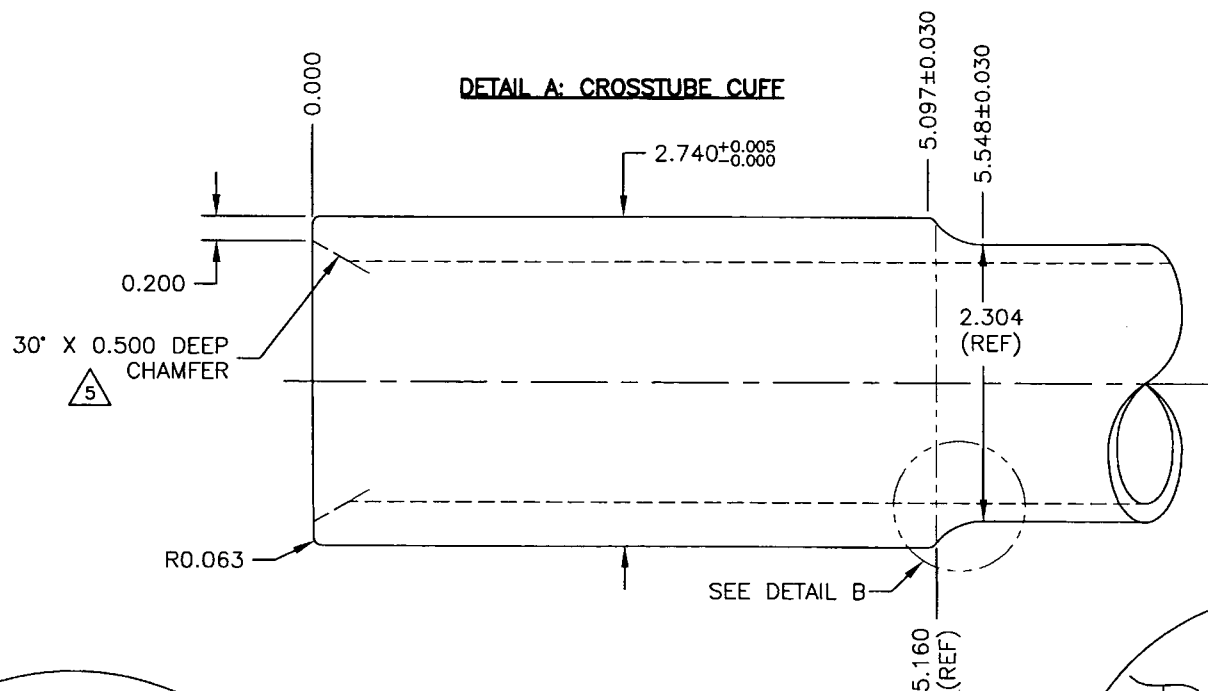
COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

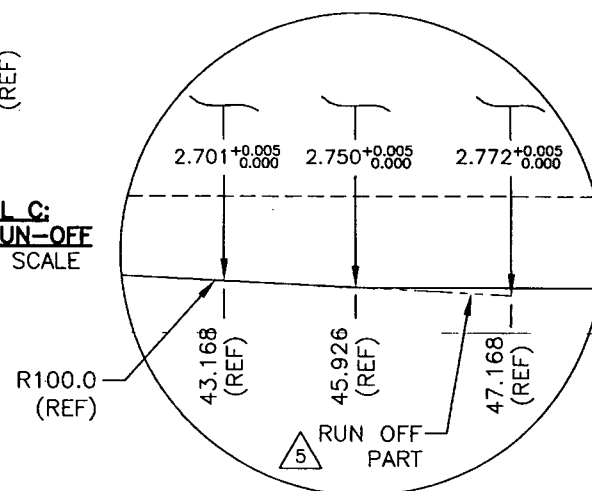
DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED	GP	APPROVED	4	DRAWING NO.	D212-664-141
DATE	07.03.08	TITLE	XTUBE ASS'Y (205/212/412 HI FWD)	REV. C	SHEET 2 OF 3
		SCALE	1:10		

NO. 355613
WORK ORDER
RETURN TO
SHOP COPY
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

RELEASED
 67.04.24 (P)
 PER CLN 837



DETAIL C: TAPER RUN-OFF
 NOT TO SCALE



NO. 35893
 WORK ORDER
 SUBJECT TO AGREEMENT
 WITHOUT NOTICE
 CONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. WILKESBURY, ONTARIO, CANADA
CHECKED A	APPROVED [Signature]	DRAWING NO. D212-664-141	REV. C SHEET 3 OF 3
DATE 07.03.08	TITLE XTUBE ASS'Y (205/212/412 HI FWD) 1:1		



LIQUID PENETRANT TEST REPORT

P - 7-1055

PAGE 1 OF 1

TIME AM ☐ PM ☐

CLIENT DART AREOSPACE

DATE DEC. 14, 2007

ATTENTION LINDA LACELLE

ACUREN JOB NO. 188-7-01055

ADDRESS 1270 ABERDEEN ST. HAWKESBURY ONT.

PO/NO. 5299

WORK LOCATION HAWKESBURY

ACCEPTANCE STD. ASTM 1417/QSI-038 REV./DATE 2005

PROJECT 212/205 HIGH FED X-TUBE, 206L FWD X-TUBES, 206BAFT X-TUBES, 206L AFT X-TUBES

ITEM(S) EXAMINED JOB #'S 35725, 35893, 36051, 36053, 36055, 36056, 36057, 36059,

JOB DESCRIPTION PROCEDURE NO. LT-0002 REV./DATE TECHNIQUE NO. LT-0002-02 REV./DATE

Part No. D206667201, D206667203, D212664101, D206667103 Material ALODYNED ALUMINUM Thickness

Scope WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE.

TEST DETAILS

Method	<input checked="" type="checkbox"/> Fluorescent	<input type="checkbox"/> Visible	<input checked="" type="checkbox"/> Water Wash	<input type="checkbox"/> Solvent Removable	<input type="checkbox"/> Post Emulsified
Family Brand	MAGNAFLUX		Black Light S/N	8178	<input checked="" type="checkbox"/> Output > 1000 μ W/cm ²
Penetrant	ZL67	Minimum Dwell time	45	Min.	<input checked="" type="checkbox"/> Ambient < 2 fc
Penetrant Remover	H20	Minimum Dry time	>10	Min.	<input checked="" type="checkbox"/> Output > 100 fc @ surface
Developer	SKDS2	Minimum Dwell time	10	Min.	Light Meter S/N
Developer Type	<input checked="" type="checkbox"/> Non Aqueous	<input type="checkbox"/> Aqueous	<input type="checkbox"/> Dry		Cal Due Date MAR 08

TEST SURFACE

Surface Condition	<input checked="" type="checkbox"/> As Ground	<input type="checkbox"/> As Welded	<input checked="" type="checkbox"/> Machined	<input type="checkbox"/> Shot Blasted	<input type="checkbox"/> Clean Bare Metal
Surface Temperature	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F to 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F to 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☐ IMPERIAL)

item	Comments	Accept	Reject
	F.L.P.I. CARRIED OUT ON 100% OF EXTERNAL SURFACE OF 212/205 HIGH FED X-TUBES JOB# 35893		
	206B AFT X-TUBES JOB #'S 36051, 35725		
	206L FWD X-TUBES JOB#'S 36053, 36055		
	206L AFT X-TUBES JOB #'S 36057, 36059, 36056		
	RESULTS: 206B AFT X-TUBE #36051 HAS ROUGH GRINDING MARKS. TO BE POLISHED AND RECHECKED AT A LATER DATE.		
	ALL OTHER JOB #'S ARE ACCEPTABLE TO ASTM 1417/ QSI-038 STANDARD.		

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

Client Representative		DTR #
Technician (Signature):		Report Reviewed by:
Name (Print):	FREDERICK CHAGNON	Name initials
	1 st technician	
CGSB Level	II SNT Level	
CGSB Reg. No	10560	
	2 nd technician	
CGSB Level	II SNT Level	
CGSB Reg. No	12247	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

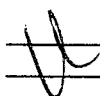
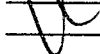
PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

Dart Aerospace Ltd.

Date: Thursday, 10/01/2008 9:07:57 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D212-664
Job Number	: 36700		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: Z_CUSTOM
This Issue	: 10/01/2008 S.O. No. :	Drawing Number	: ECN 1103
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LANDING GEAR	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: 	Due Date	: 17/01/2008 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

PULL FROM STK:

(17)

-4
-4

D212-664-101
D212-664-201

35892 - 35891 - 35539
35929 - 35928 - 35890 - 35893 - 35927 - 35541 -
32681 - 32684 - 32680 - 34586 - 32151
35725 - 35056 - 35106

ADD NEW PAPERWORK TO KITS IN STK
FAA STC: SR01298NY, PER ECN 1103

RETURN TO STOCK

17x 8/1/11 SP

2.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.06.11